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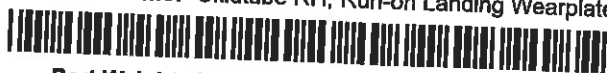
D350-636-016
Job Sheet 200934



Part No: D350-636-016

Job Qty: 1 pcs

Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 10/25/19

Description: SIOP

Type: Stock

Note: DWG D4168-042 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP REV:D 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:E 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/25/19		0.00	4.78	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	10/25/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/25/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

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9/19/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

						QC 5 - 58		
						QC 5 - 68	OCT 10 2019	DAS 68
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
						QC 5 - 61		
						QC 5 - 81		
						Handfinish - 1 - 1 - B4B		
						Handfinish - 1 - 2 - B4B		
140 Handfinish - 1-1 Chemical-B4B	1 pcs	10/25/19	0.00	0.98		Handfinish - 1 - 3 - B4B		
						Handfinish - 1 - 4 - B4B		
						Handfinish - 1 - 5 - B4B		
						Handfinish - 1 - 6 - B4B		
						Handfinish - 1 - 7 - B4B		
						Handfinish - 1 - 8 - B4B		
						Handfinish - 1 - 9 - B4B		
						Handfinish - 1 - 10 - B4B		
						Handfinish - 1 - 11 - B4B		
						Handfinish - 1 - 12 - B4B		
						Handfinish - 1 - 13 - B4B		
						Handfinish - 1 - 14 - B4B		
						Handfinish - 1 - 15 - B4B		
						Handfinish - 1 - 16 - B4B		
						Handfinish - 1 - 17 - B4B		
						Handfinish - 1 - 18 - B4B		
						Handfinish - 1 - 19 - B4B		
						Handfinish - 1 - 20 - B4B		
						Handfinish - 1 - 21 - B4B		
						Handfinish - 1 - 22 - B4B		
150 QC 7	1 pcs	10/25/19	0.00	0.00		QC 7 - 10		
						QC 7 - 13		
						QC 7 - 14		
						QC 7 - 15		
						QC 7 - 17		
						QC 7 - 18		
						QC 7 - 19		
						QC 7 - 2		
						QC 7 - 28		
						QC 7 - 3		
						QC 7 - 30		
						QC 7 - 34		
						QC 7 - 36		
						QC 7 - 37		

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[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

						QC 7 - 41	
						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
						QC 7 - 61	
						QC 7 - 81	
						QC 7 - 79	
160 Skidtubes - 2 - B4B	1 pcs	10/25/19	0.00 4.78	1:43 TF 2h @		Skidtubes - 1 - B4B	DD
						Skidtubes - 2 - B4B	DD
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	TF
						Skidtubes - 5 - B4B	SE
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/25/19	0.00 0.00			QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	
						QC 10 - 58	
						QC 10 - 9	
180 QC 5	1 pcs	10/25/19	0.00 0.00			QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/25/19	0.00 0.33			Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	
						Handfinish - 2 - 4 - B4B	

OCT 28 2019 DAS 68 9-89

OCT 28 2019 DAS 68 9-89

OCT 29 2019

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9/19/2019

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DAS

41 OCT 29 2019

9-89

200 Spray Paint - 2 - B4B

1
pcs

10/25/19

0.00 0.61

Spray Paint - 1 - B4B

Spray Paint - 2 - B4B

Spray Paint - 3 - B4B

Spray Paint - 4 - B4B

210 QC 14

1
pcs

10/25/19

0.00 0.00

QC 14 - 15

QC 14 - 2

QC 14 - 34

QC 14 - 41

QC 14 - 51

QC 14 - 58

QC 14 - 59

QC 14 - 9

QC 14 - 68

QC 14 - 40

QC 14 - 19

QC 14 - 43

QC 14 - 24

QC 14 - 61

QC 14 - 81

FEB 19-10-3d

DAS
59

220 Packaging 2-1 - Receive - B4B

1
pcs

10/25/19

0.00 0.00

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

Packaging 2 - 3 - B4B

Packaging 2 - 5 - B4B

Packaging 2 - 4 - B4B

Packaging 2 - 6 - B4B

Packaging 2 - 7 - B4B

Packaging 2 - 8 - B4B

Packaging 2 - 9 - B4B

Packaging 2 - 10 - B4B

Packaging 2 - 11 - B4B

Packaging 2 - 12 - B4B

Packaging 2 - 13 - B4B

Packaging 2 - 14 - B4B

Packaging 2 - 15 - B4B

Packaging 2 - 16 - B4B

Packaging 2 - 17 - B4B

Packaging 2 - 18 - B4B

Packaging 2 - 19 - B4B

Packaging 2 - 20 - B4B

Packaging 2 - 21 - B4B

Packaging 2 - 22 - B4B

Packaging 2 - 23 - B4B

Packaging 2 - 24 - B4B

Packaging 2 - 25 - B4B

Packaging 2 - 26 - B4B

Packaging 2 - 27 - B4B

Packaging 2 - 28 - B4B

Packaging 2 - 29 - B4B

Packaging 2 - 30 - B4B

Packaging 2 - 31 - B4B

Packaging 2 - 32 - B4B

Packaging 2 - 33 - B4B

Packaging 2 - 34 - B4B

Packaging 2 - 35 - B4B

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230 Handfinish - 4-1-Assembly-B4B	1 pcs	10/25/19	0.00 0.98	Packaging 2 - 36 - B4B	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	BFB 19-10-30
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	10/25/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 30 2019
				QC 5 - 61	
				QC 5 - 81	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	10/25/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	DAS
				Packaging 1 - 3 - B4B	74
				Packaging 1 - 4 - B4B	9-89
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	

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				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260	QC 4	1	10/25/19	0.00 0.00	QC 4 - 28
		pcs			QC 4 - 58
					QC 4 - 69
					QC 4 - 9
					QC 4 - 46
					QC 4 - 68
					QC 4 - 72
					QC 4 - 74
					QC 4 - 75
270	Packaging 3-1 - Stock - B4B	1	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B

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				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21
275 DC - 1 - B4B	1	10/25/19	0.00 0.00	DC - 1 - B4B	NOV 19 2019
	pcs			DC - 2 - B4B	
280 QC 21 - FG	1	10/25/19	0.00 0.00	QC 21 - FG - 21	DAS 21 NOV 19 2019
	pcs			QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT

Descriptions: end per dwg D4168-2 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 5 (D4168-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R-R and open to 0.500" 5- Drill tow ring hole using DT9616 detail "J" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) +.201" (total of one hole per side DT9616) as per dwg D4168. 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skid tubes) 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 520025 exp. date: 07.25.20 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AP-AP drill out x-bolt spacer to 0.404" 10- Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint. ***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** REF TO W/O BATCH:

170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125
 210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 220 - Receive and inspect for damage + mat'l certs
 230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-4, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5200625 EXP DATE: 20207 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138843 5-Coat all exposed fasteners with "LPS Procyon" batch: 1133690
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit) If making a D350-636-216 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1
 260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****
 270 - Identify and pack for shipping as per PPPD350-636-016 Location: FG071
 275 - (Document Control) record fwd angle: 89.8 Photocopy blue file and type labels per PPP D350-636-016 CHG 006
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	21 pcs (1 ea)	110-Skidtubes - 1	5197882 x2
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5218860
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5194932
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5210529
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5222157
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5203363
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	FM138009
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5049457
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	1x5216233/3x222331
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5221549
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5219776
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5215785
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5218656
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5215332
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5215514
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5192242
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180790
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5216287
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5215506-1
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5218154
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-3
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5214921
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5217830
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5199935
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5222755
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5108570
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184464
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5210551
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5225622
MS21053C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215500
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166710

M. U. 012711

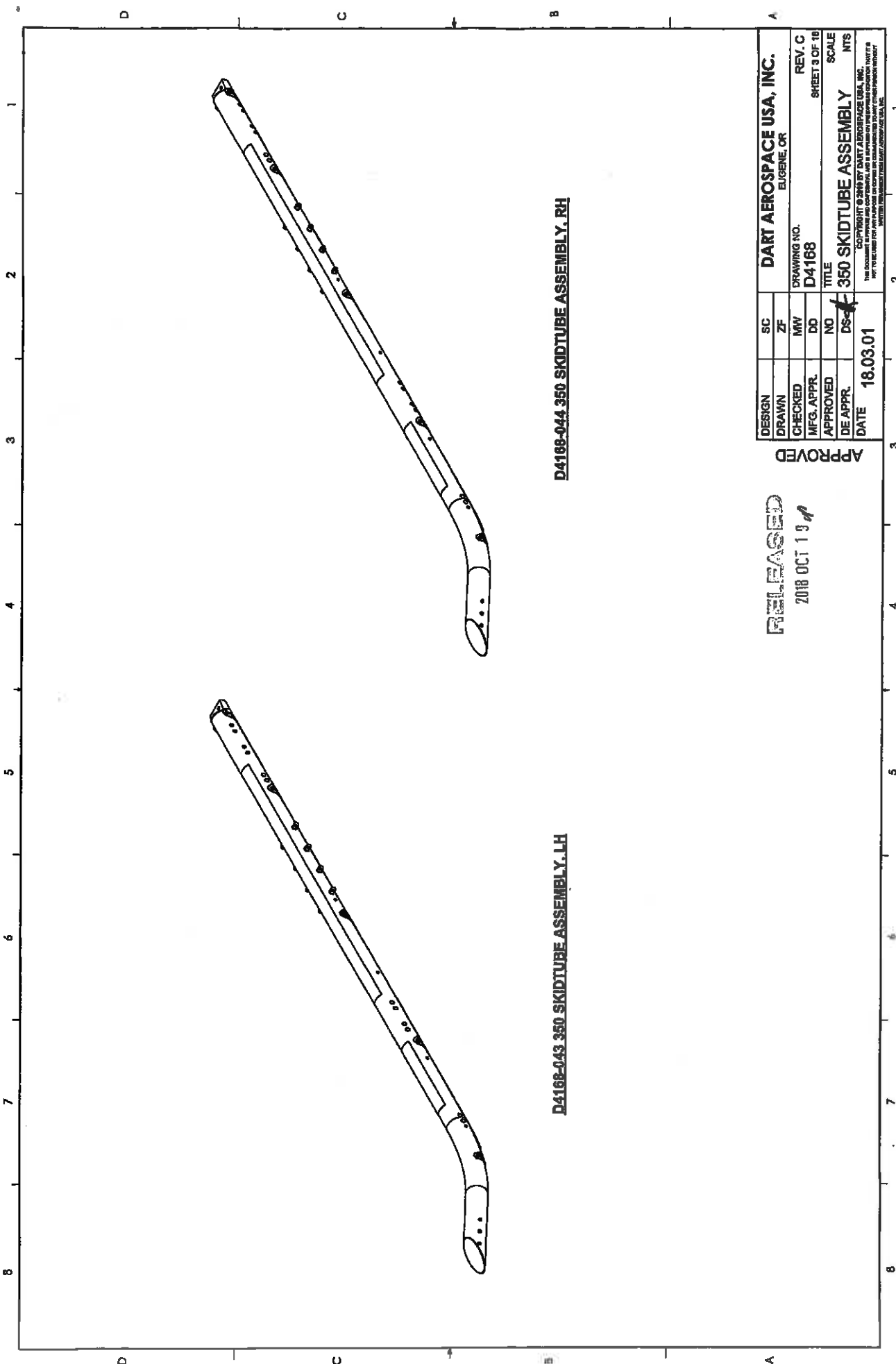
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	2	0
	D2744	1	38	0
160-Skidtubes - 2 - B4B	D2739	1	4	0
	D2743	8	369	0
	D3490-1	4	190	0
	D3490-3	4	21	0
	ALS4-1032-225	4	1,872	0
230-Handfinish - 4-1-Assembly-B4B	AN3C34A	1	33	0
	AN3C36A	4	199	0
	AN3C6A	4	95	0
	AN6C44A	4	60	0
	AN8C35A	1	14	0
	D2745	8	104	0
	D3488-4	1	18	0
	D3492-1	8	92	0
	D3492-3	8	50	0
	D3631-1	8	256	0
	D3873-1	7	38	0
	D4154-041	1	7	0
	D4170-1	4	125	0
	D4171-1	1	21	0
	MS21043-3	5	567	0
	MS21043-6	4	48	0
	MS21083C8	1	44	0
	NAS1149C0332R	4	2,920	0
	NAS1149C0363R	9	549	0
	NAS1149C0832R	1	267	0
	NAS1515H3L	4	243	0
	NAS1611-010	8	131	0
	NAS1611-013	8	128	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	79	0
	AN3C42A	1	71	0
	AN8C21A	2	81	0
	D2741	1	65	0
	D3493-1	2	37	0
	MS21083C8	2	44	0
	NAS1149D0863J	2	325	0

Part Specifications

Specifications could not be found.

Plex 9/19/19 10:54 AM Dart.Renwick.Jennifer



D4168-044 350 SKIDTUBE ASSEMBLY, RH

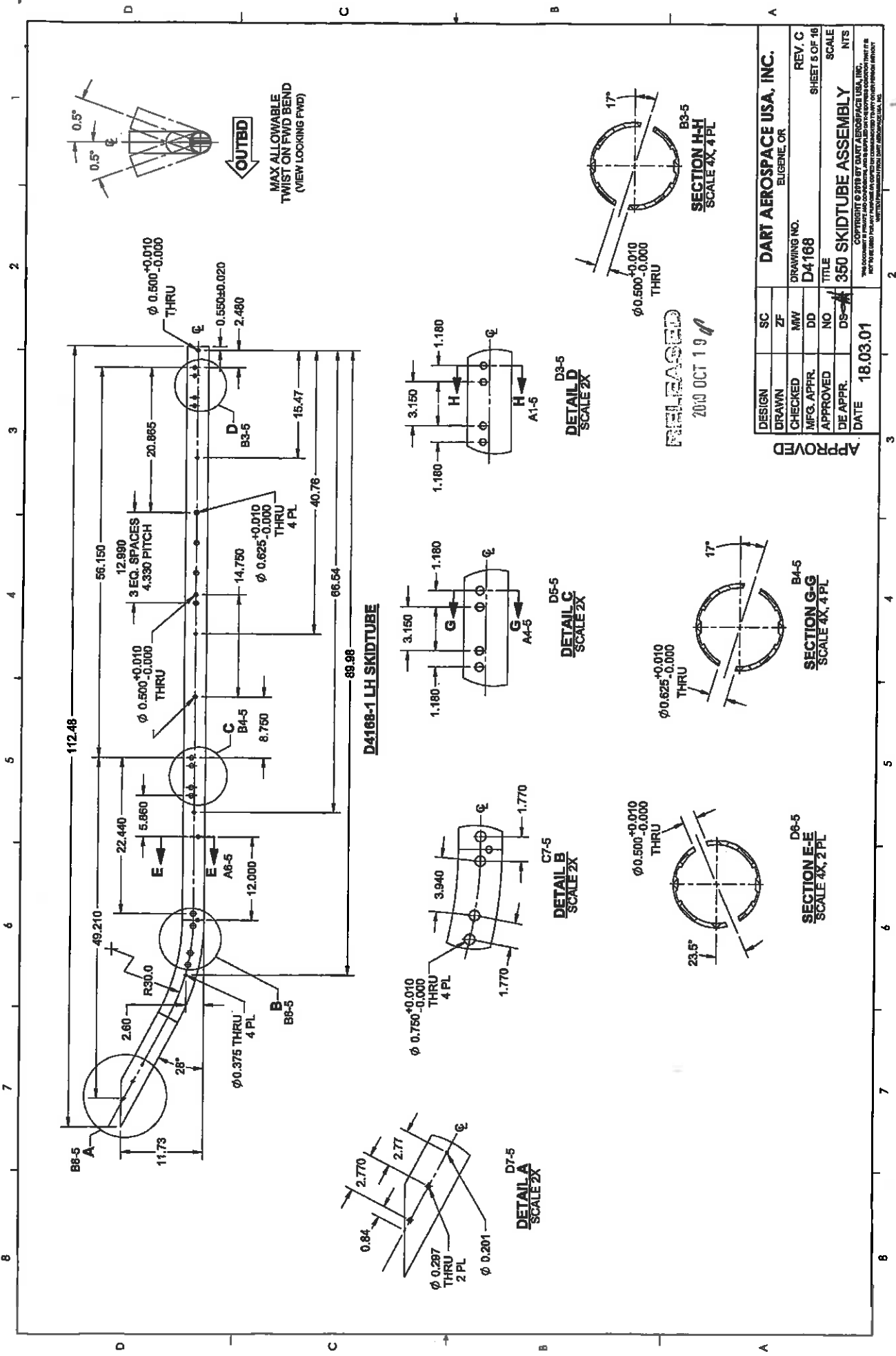
D4168-043 350 SKIDTUBE ASSEMBLY, LH

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MM	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS- F	350 SKIDTUBE ASSEMBLY	NTS
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APPROVED

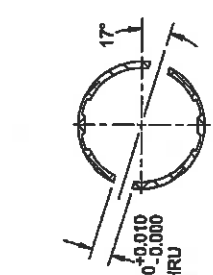
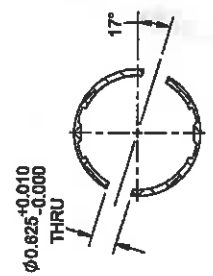
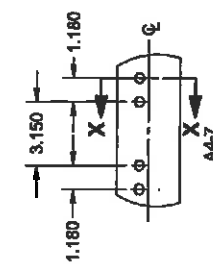
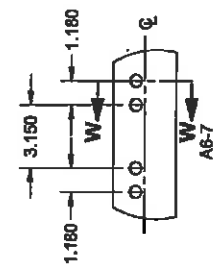
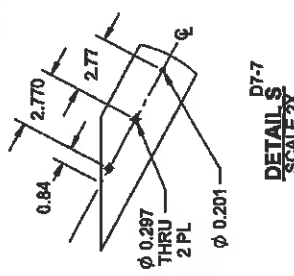
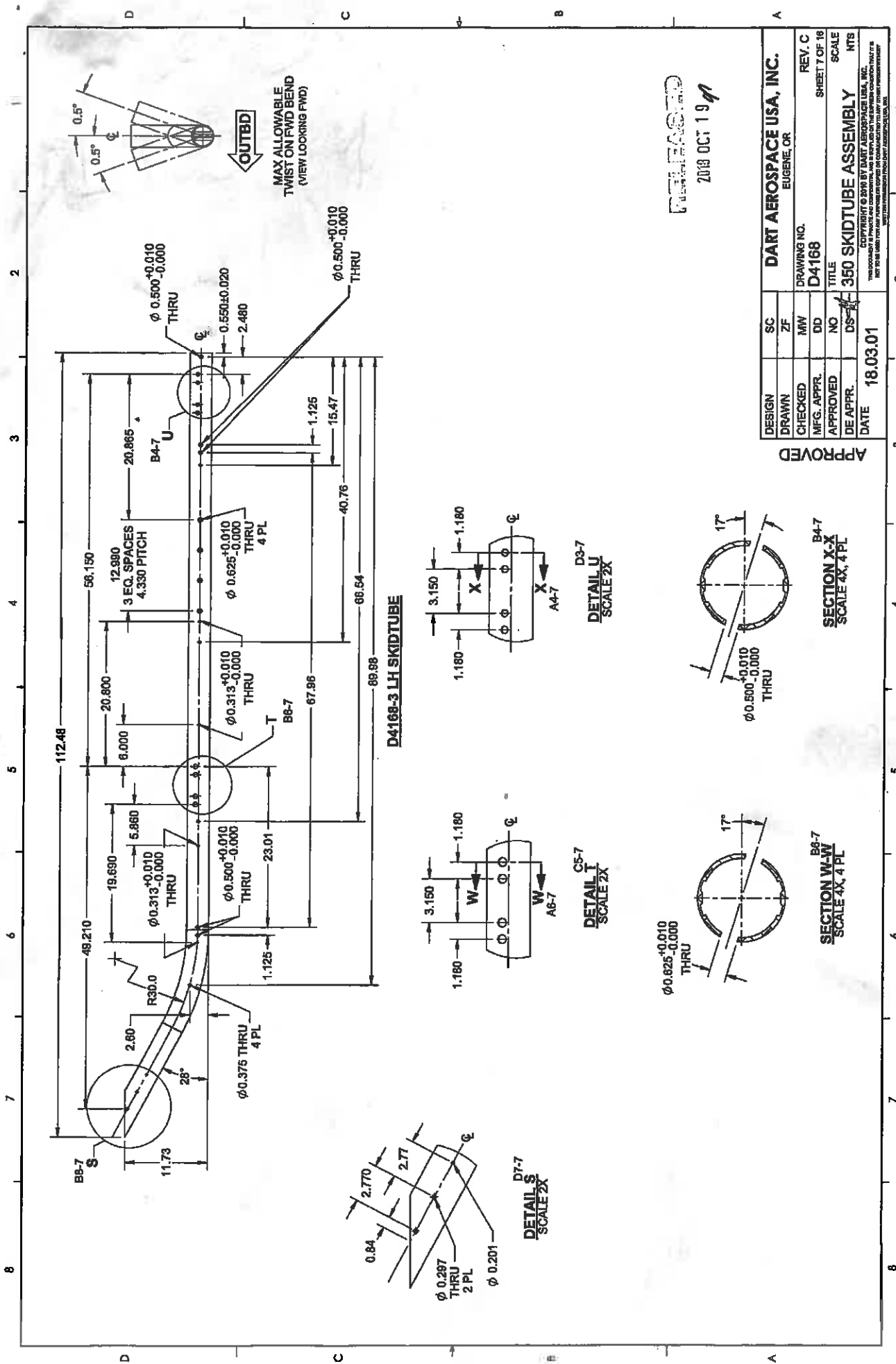
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2018 OCT 13



DESIGN	SC	ELIGENE OR	DART AEROSPACE USA, INC.
DRAWN	ZF		
CHECKED	MMV	DRAWING NO.	REV. C
INFG. APPR.	DD	D4168	SHEET 5 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01		

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DESIGN	SC	SC	DART AEROSPACE USA, INC.
DRAWN	ZF	ZF	EUGENE, OR
CHECKED	MW	MW	DRAWING NO.
MFG. APPR.	DD	DD	D4168
APPROVED	NO	NO	REV. C
DE APPR.	DS	DS	SHEET 7 OF 18
DATE	18.03.01	18.03.01	SCALE
			NTS

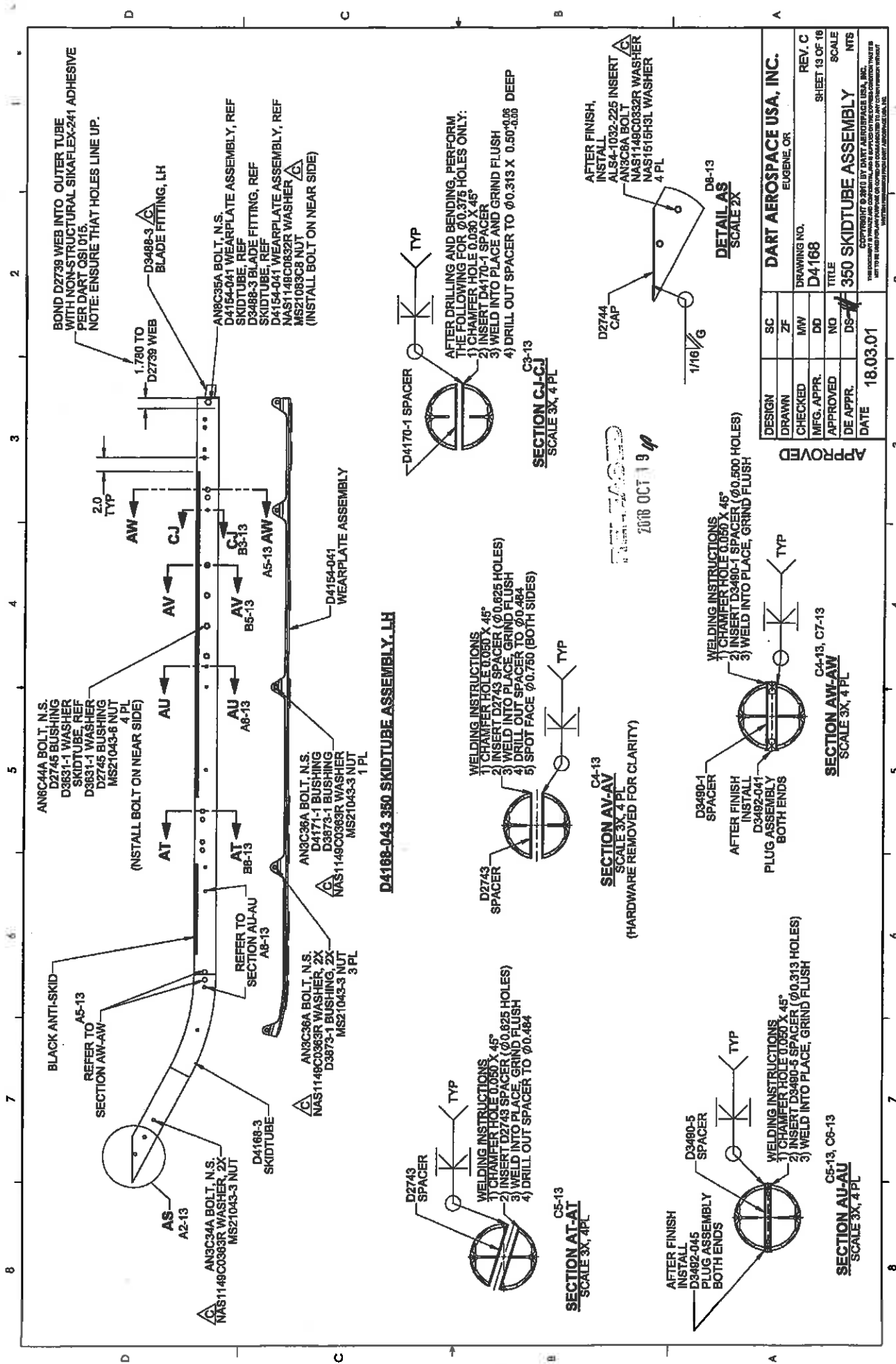
APPROVED

RELEASED
2018 OCT 19

B4-7
SECTION X-X
SCALE 4X, 4 PL

B6-7
SECTION W-W
SCALE 4X, 4 PL

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DESIGN	SC	REV. C
DRAWN	ZF	DRAWING NO.
CHECKED	MW	D4168
ENG. APPR.	DD	SHEET 13 OF 18
APPROVED	NO	TITLE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY
DATE	18.03.01	SCALE
		NTS



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐
Machining ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐
Large Fab ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐
Finishing ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐ ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐
Equipment/Tooling ☐ ☐ ☐ ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐
Material ☐ ☐ ☐ ☐ ☐ ☐
Product Improvement ☐ ☐ ☐ ☐ ☐ ☐
Process Improvement ☐ ☐ ☐ ☐ ☐ ☐
Human Factors ☐ ☐ ☐ ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Bending ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Crushing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Cracks ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Contamination ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Weld ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Other/Details: _____

Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Drawing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Finish ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
Misread ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3451	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAISER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D274	BLADE
10	2	2	2	2	2	2		AN8C211	BOLT
11	2	2	2	2	2	2		NAS1149CO863	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K
Date: 18.04.04